

Date: Thursday, 14/08/2008 3:47:47 PM  
User: Linda Lacelle

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER  
Job Number : 41252  
Estimate Number : 13550  
P.O. Number : Part Number : D32343  
This Issue : 14/08/2008 S.O. No. : Drawing Number : D3234 REV A  
Prsht Rev. : NC Project Number : N/A  
First Issue : / / Type : SMALL /MED FAB Drawing Revision : A  
Previous Run : Material :  
Written By : Due Date : 21/08/2008 Qty: 4 Um: Each  
Checked & Approved By :  
Comment : Est Rev: A New Issue 08-08-14 JLM Verified By: EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S050 2024-T3 .050 sheet



Comment: Qty.: 0.2273 sf(s)/Unit Total : 0.9093 sf(s)

2024-T3 .050 sheet

BATCH: 107711 HB 8-8-15

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3234

Dwg Rev: A HB 8-8-15

Prog Rev: A

2-Deburr if necessary HB 8-8-15

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1





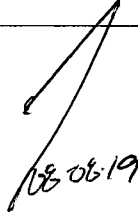

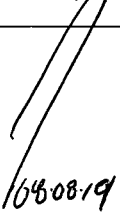
Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3233-3 PAR #: NO Fault Category: ENG-DWG NCR: Yes No DQA: NA Date: 08.08.24  
DS19269-011 (DS56-689) QA: N/C Closed: AD Date: 08/29/26

NCR: 41252		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-08-19	4.0	No hole dimensions to specify the pitch & location on the dwg.  R.C. holes are to be drilled into the aircraft per DS1 9269-011		- Parts are acceptable, as per dwg. & DS1 instructions.  - PAR 08-029 raised for hole pitch.	N/A 	 08-08-19.	 08-08-19	 08-08-19

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 41252

Part Number: D32343

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



3x  
36

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/8/20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



3x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 176

8/8/20

50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/20 PJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.08.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

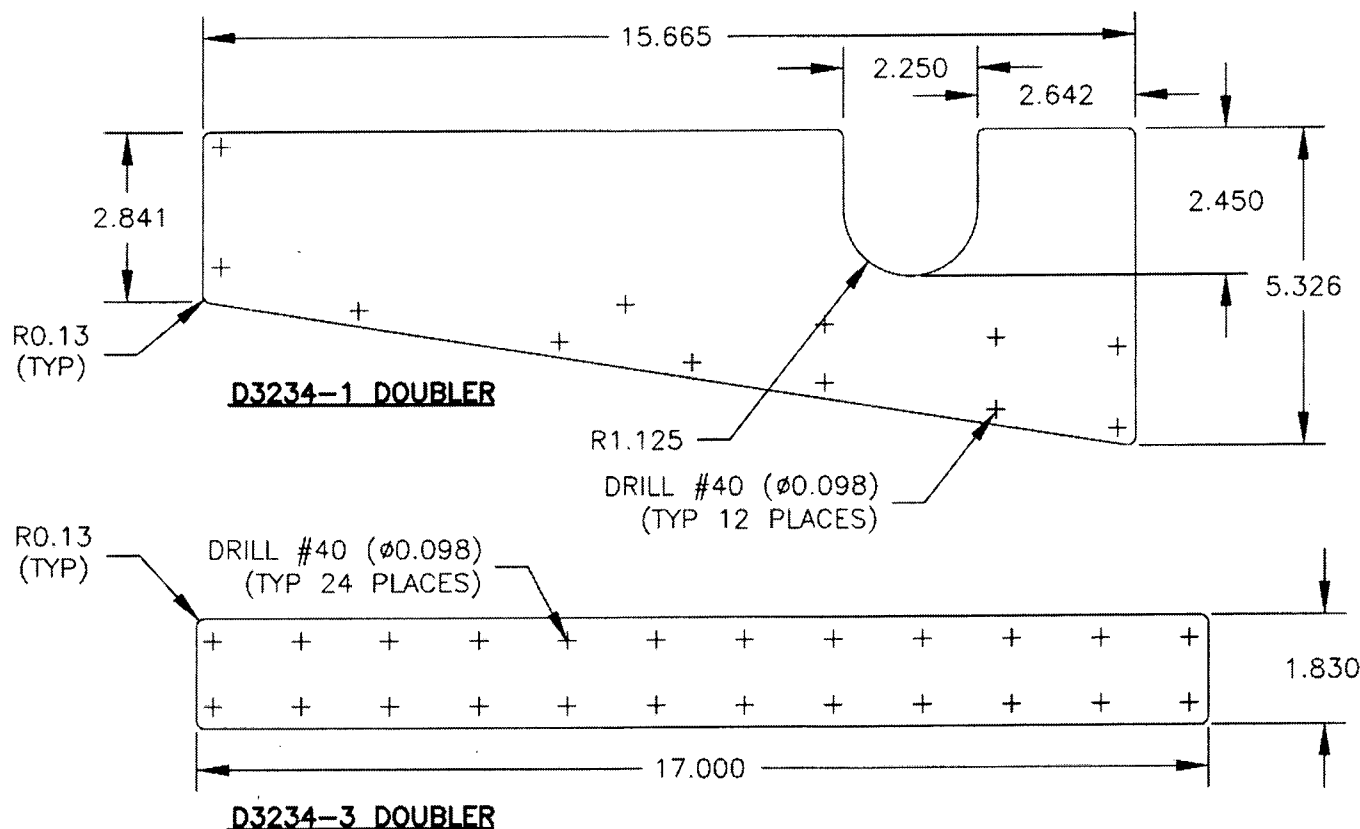
NOTE: Date & initial all entries

ISI 9269-011

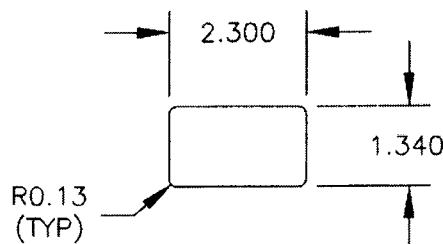
~~D350~~



DESIGN <i>IP</i>	DRAWN BY <i>IP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3234	REV. A SHEET 1 OF 1
DATE 03.11.19		TITLE DOUBLER	SCALE 1:3
A	03.11.19	NEW ISSUE	



RELEASED  
03 11 24 *A*



**D3234-5 SPACER**

*w/041252*

**D3234-1/-3 DOUBLER. D3234-5 SPACER**

- 1) MACHINE PARTS PER DWG FILE "D3234-A.DWG"
- 2) MATERIAL: -1/-3: 2024-T3 (QQ-A-250/4), 0.050 THICK (REF DART SPEC. M2024T3S.050)  
-5: 5052-H32 (QQ-A-250/8), 0.050 THICK (REF DART SPEC. M5052H32S.050)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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